












Date: Tuesday, 07/04/2009 3:22:49 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ADJUSTABLE ATTACHMENT ARM ASSY
Job Number	: 47060		
Estimate Number	: 13479		
P.O. Number	:	Part Number	: PB674300159
This Issue	: 07/04/2009 S.O. No. :	Drawing Number	: B6743001 P.14
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 07/04/2009 Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 45801	Material	:
Written By	:	Due Date	: 14/04/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 09-04-08.</u>		
Comment	: Est Rev:A 08-07-18 new issue DD verified by:ec Est Rev:B 08-11-21 Qty for BSP43 revised per W/O 43054 KJ Verified by: eC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	PB6743001113	Square Tubing	
✓			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Square Tubing batch: <u>B45256 = 1X</u> <u>sp 09.04.13</u>			
2.0	PB6743001119	End Cap Clevis	
✓			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) End Cap Clevis batch: <u>B41478 = 1X</u> <u>sp 09.04.13</u>			
3.0	PB6743001117	Hook Plate	
✓			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Hook Plate batch: <u>B41865 = 1X</u> <u>sp 09.04.13.</u>			
4.0	PB6743001115	Tube End Plate	
✓			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Tube End Plate batch: <u>B24087 = 1X</u> <u>sp 09.04.13.</u>			
5.0	PB6743001271	Doubler	
✓			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Doubler batch: <u>B44975 = 2X</u> <u>sp 09.04.13</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:22:49 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 47060

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W



Comment: Qty.: 0.1575 f(s)/Unit Total: 0.1575 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: M 108551

SP 09-04-13

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit on -113 as per dwg

PB67-43001

SP 09-04-13

(IX)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09-04-13

(IX)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/13

(IX)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M

09-04-15

(XI)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

2:20pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:50pm

del

09-04-16

(XII)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ

09/04/16

(XIII)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 47060

Part Number: PB674300159

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	PB6743001267	PB67-43001-267
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-267

batch:

44976

SS 09/04/17 (X)

14.0	PB6743001121	Square Sleeve
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Square Sleeve

batch:

43329

SS 09/04/17 (X)

15.0	BSP43	RIVET
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

RIVET

batch:

M109119

SS 09/04/17 (X)

16.0	MS17984C413	PIN, QUICK RELEASE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch:

M109031

SS 09/04/17 (X)

17.0	30345T21	LANYARD
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LANYARD

batch:

M17528

SS 09/04/17 (X)

18.0	MS27039122	SCREW
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch:

18057

SS 09/04/17 (X)

19.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch:

M110844

SS 09/04/17 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:22:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 47060

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

NAS1149F0332P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

batch:

M18057

8/09/04/17xi

21.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001

2- deburr and rivet -267 to -113 as per dwg

3- assemble rest of parts as per dwg PB67-43001

09.04.20

PTO

X1

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/20

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

473A

9/4/20

R

SP

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/20

Job Completion



09.04.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-04-20	#21.0	ADD WASHER to PART - (267) AN960-4L → M101389 Qty 4	CP 090420	09-04-20	1	09-04-20	09/04/20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
#47060

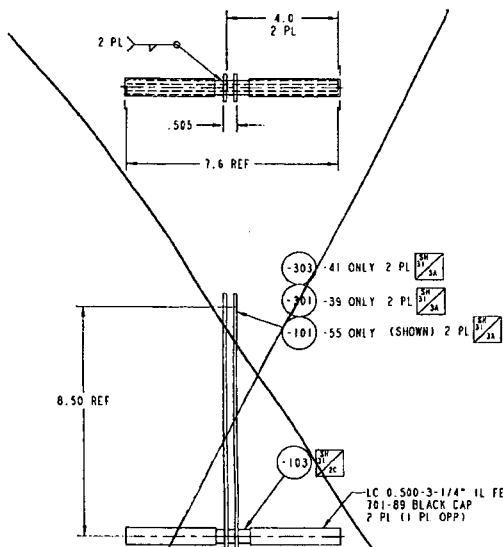
8 7 6 5 4 3 2 1

D

C

B

A

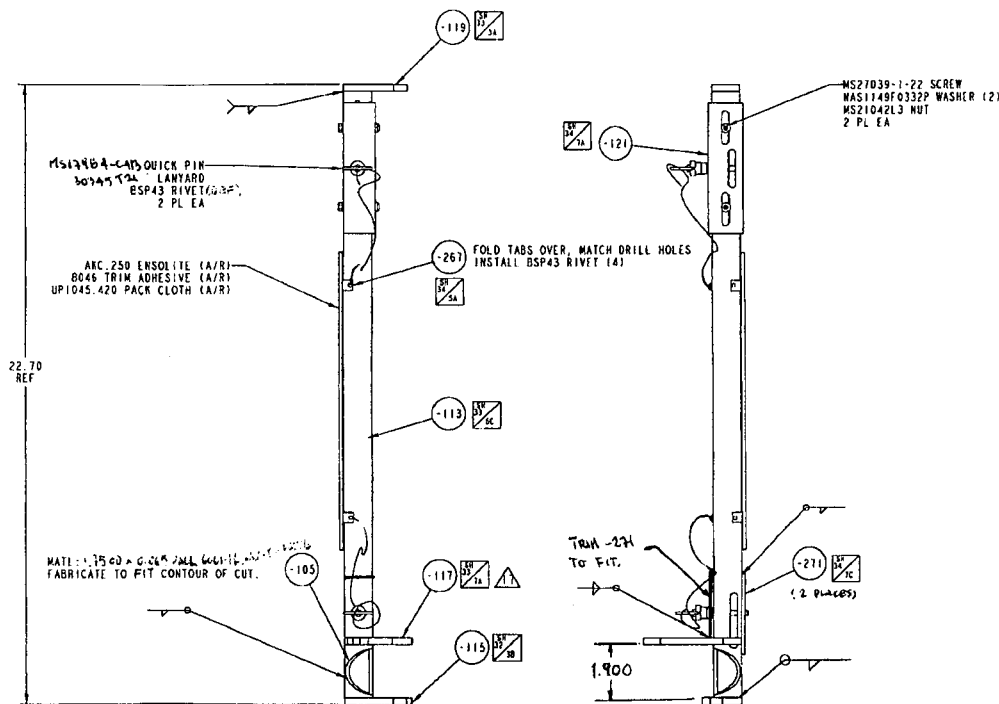


- ① -39 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ① -41 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ② -55 HANDLE AND LOCK-DOWN ASSEMBLY (SHOWN)

SCALE 0.500

SUPERCEDED BY

SUPERSEDED BY D3451-041/-043/-045/-047



- ① -59 ADJUSTABLE ATTACHMENT ARM ASSY

SCALE 0.500

#47060

8 7 6 5 4 3 2 1

PREMIER AVIATION, INC.			
8000 Aviation Parkway, Grand Prairie, Texas 75052			
DATE	CONF. NO.	REV. NO.	REV.
D	OSUV8	B67-43001	B1
SCALE	BY	DATE	12 OF 45

ORIGINAL